



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBE350A93-3316-20
Job Sheet 189775



Part No: RBE350A93-3316-20

Job Qty: 2 pcs

Part Name: Rotating Star Replacement Wrench



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/30/19

Job Tracking No:

Due Date: 4/15/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBE350A93-3316-20 REV:C IPP REV A 18.01.23 NEW ISSUE RQ VERIFIED BY DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Small Fab - 1	2 pcs	4/15/19		0.00	2.00	Small Fab - 1		MLC
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
120	QC 5	2 pcs	4/15/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 38		
							QC 5 - 42		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
130	Packaging 3-1 - Stock - B4B	2 pcs	4/15/19		0.00	0.00	QC 5 - 9		MAR 11 2019
							QC 5 - 50		
							QC 5 - 30		
							Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		DAS 28 9:39
							Packaging 3 - 5 - B4B		
							Packaging 3 - 6 - B4B		



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S160968



Part: RBE350A93-3316-20

Job No: 189775

Serial No/Batch: S160968

Revision: C

Inspector:

Exp Date:

Instructions:

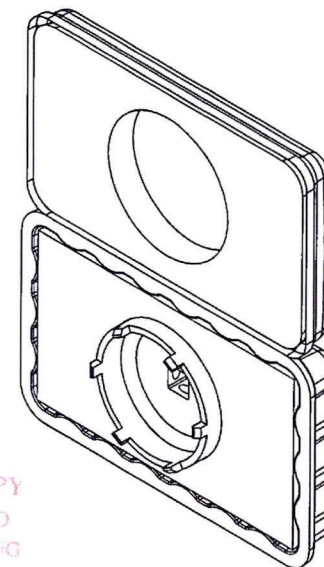
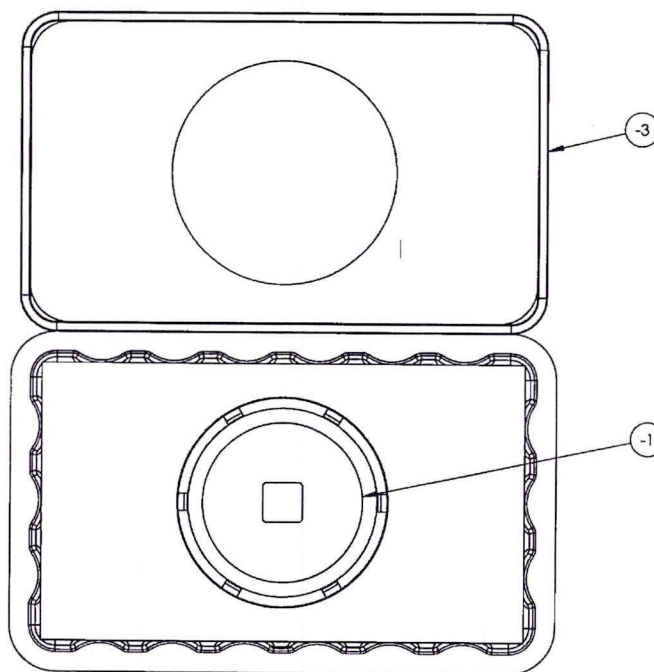
Date: 03/11/19

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				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
140	QC 21 - SA	2 pcs	4/15/19	0.00 0.00	QC 21 - SA - 21
					QC 21 - SA - 70
					DAG 21 9-88
					MAR 11 2019
Part Op 110 - (Small Fab) Pick kit as per DWG. Descriptions: 120 - QC5- Inspect part completeness to step on W/O) 130 - (Identify as per dwg & Stock Location: _____) 140 - (QC21- Final Inspection - Work Order Release)					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
APP-1040-E	Case	2 pcs (1 ea)	110-Small Fab - 1	515 7534	
RBE350A93-3316-20-1	Rotating Star Replacement Wrench	2 pcs (1 ea)	110-Small Fab - 1	5107555	
RBE350A93-3316-20-5	Top Foam use in case APP-1040-E	2 pcs (1 ea)	110-Small Fab - 1	5157539	
RBE350A93-3316-20-7	Bottom Foam use in case APP-1040-E	2 pcs (1 ea)	110-Small Fab - 1	5157533	
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
110-Small Fab - 1	APP-1040-E	2	2	0	
	RBE350A93-3316-20-1	2	8	0	
	RBE350A93-3316-20-5	2	0	0	
	RBE350A93-3316-20-7	2	0	0	
Part Specifications					
Specifications could not be found.					

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ITEM #	QTY	PART #	TITLE	PG	REV.	DESCRIPTION	ECN #	DATE	BY	APPROVED
-1	1	RBE350A93-3316-20-1	ROTATING STAR REPLACEMENT WRENCH	2	1	OPENED TOLERANCES ON I.D., O.D., LENGTH, AND TOOTH WIDTH, WAS .232 ±.005. ALSO ADDED BALL LOCK GROOVE TO 1/2 IN. DRIVE.	-	9/28/2009	WP	DW
-3	1	RBE350A93-3316-20-3	PACKAGING ASSY	3	1A	ADDED MISSING Ø.600 DIMENSION.	-	9/15/2011	RJC	RW
					2	CHD RADIUS WAS .094 IS .109.	-	4/19/2013	CFS	GE
					2A	CHD T/N WAS RBEA93-3316-20 IS RBE350A93-3316-20. CHD TOOL NAME WAS WRENCH, TAIL ROTOR SPIDER NUT IS ROTATING STAR REPLACEMENT WRENCH.	-	10/23/2013	CFS	-
					3	UPDATED TO NEW DRAFTING STANDARD. CHD DIM WAS .505 SQUARE IS 2X .508/.503. ADDED DIM 2X .670. CHD MAT'L WAS 4140 Q&T IS 4140/4142. ADDED HEAT TREAT RC 28-32. ADDED FINISH SPEC QMSI-6.2.2, B.O. REV D. ADDED NOTE 2 SHT 1.	17-0130	6/1/2017	RJC	JAG
					C	ITEM 1 BECOME -1, PACKAGING ASSY -3 ADDED	17-800	17.12.22	VM	ML



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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 159775 MLJ
19-0130

NOTES:
1) MATERIAL: N/A
2) HEAT TREAT: N/A
3) FINISH: N/A
4) SPEC: N/A
5) BREAK ALL SHARP EDGES: N/A
6) IDENTIFICATION: N/A

RBE350A93-3316-20 ROTATING STAR REPLACEMENT WRENCH

DART AEROSPACE		Hawkesbury, Ontario, Canada	
TITLE ROTATING STAR REPLACEMENT WRENCH			
PART NO. RBE350A93-3316-20		REV C	
TOOL NO. RBE350A93-3316-20		UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN INCHES INTERPRET PER ASME Y14.5M-2009 DIMENSIONS APPLY AFTER FINISHING	
INITIALS AND DATE		TOLERANCES:	
DESIGNED BY:	VM 17/12/22	XX ±.008	FRACTIONS ± 1/8
DRAWN BY:	VM 01/02/2018	XX ±.01	ANGLES ±.5°
CHECKED BY:	VM 01/02/2018	X ±.1	SURFACE ROUGHNESS
MPG REVIEW BY:	DD 01/02/2018	SCALE: NTS	
APPROVED BY:	ML 01/05/2018	SHEET 1 OF 8	
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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					